



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-564-011
Job Sheet 178913



4175

Part No: D205-564-011

Job Qty: 4 ea

Part Name: Bell Medium Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV I SHEET 27 IPP F 00.01.20 Changed pick list, MPP 2019, CHG006 EC IPP Rev:G 06-08-28 As per Rev E JLM IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC IPP Rev:I 08-10-01 New Manufacturing Method JLM Verf By:EC IPP REV:J 15.06.05 as per ecn15-574/chg009 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-1		3/AS/13/2018
110	Packaging	4 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-2		6 SEP 12 2018
120	QC	4 pcs	7/6/18	7/6/18	0.00	0.00	QC4		9-89
130	Packaging	4 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		8/8/2018
135	DC	4 pcs	7/6/18	7/6/18	0.00	0.00	DC		18.09.12
140	QC21-FG	4 Ea	7/6/18	7/6/18	0.00	0.00	QC21		18.09.12

Part Op 130 - Identify and pack for shipping as per PPP D205-564-011 LOCATION: FG015
Descriptions: 135 - Photocopy blue file and type labels per PPP D205-564-011 CHG009

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	80 Ea (20 ea)	90-Start up Operation	
D2274	Radius Block	80 Ea (20 ea)	90-Start up Operation	
D2521	Individual Bearpaw	8 Ea (2 ea)	90-Start up Operation	
D2529	Washer	80 Ea (20 ea)	90-Start up Operation	
D3544-041	Clamp	16 Ea (4 ea)	90-Start up Operation	
D4060-1	Ski Clamp, Top	32 Ea (8 ea)	90-Start up Operation	
D4061-1	Ski Cushion	32 Ea (8 ea)	90-Start up Operation	
MS21042L4	Nut	80 Ea (20 ea)	90-Start up Operation	
NAS1149D0463J	Washer	80 Ea (20 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	80	289	0
	D2274	80	251	0
	D2521	8	9	0
	D2529	80	1,837	0
	D3544-041	16	13	0
	D4060-1	32	52	0
	D4061-1	32	322	0
	MS21042L4	80	2,959	0
	NAS1149D0463J	80	5,122	0

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
								Positioned Wrong	
Root Cause		FAULT CAT						Outside Dimensions	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Over/Under tolerance					
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Part Incorrect					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Part Lost/Missing					
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Part Moved					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualifi ☐	Drawing					
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Finish					
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Misread					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Turning Sequence					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐						
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART
 AEROSPACE
 Container No: S109299
 Part: D205-564-011
 Job No: 178913
 Serial No/Batch: S109299
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH96 - 42 Issue 6a F A A STC SR005711

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Part Specifications

Specifications could not be found.

Plex 6/11/18 10:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004175	S088537	AN4-15A	Bolt	s083012	OVER003	80
004175	S067935	D2274	Radius Block	S067930	ST006	54
004175	S088539	D2529	Washer	S035698	ST008	80
004175	S061541	D4060-1	Ski Clamp, Top	S061540	ST542	20
004175	S088652	D4061-1	Ski Cushion	f153230	ST544	32
004175	S088507	MS21042L4	Nut	s075983	ST303	80
004175	S088502	NAS1149D0463J	Washer	s067900	ST263	80

265089483

S083112x42

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

03544.041 S083919 X16

Plex 7/3/18 7:47 AM dart.quirion.sonia

D2521 S082991



5.0 PARTS LISTS

Note: Additional fasteners may be included depending on the configuration being installed.

5.1 Parts List Bearpaw Installation

(For Skidtubes equipped with Standard Wearplates)

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D205-564-011	BEARPAW INSTALLATION
	X		D205-564-013	BEARPAW SKI INSTALLATION
		X	D205-564-015	SKI UPGRADE KIT
20	52	36	D2274	RADIUS BLOCK
2	2		D2521	BEARPAW
20	12	12	D2529	WASHER
4			D3544-041	CLAMP
	2	2	D3795-1	SKI FWD SECTION
	2	2	D3795-3	SKI MID SECTION
	2	2	D3796-041	FWD WEARPLATE
	2	2	D3796-043	AFT WEARPLATE
8	26	18	D4060-1	CLAMP (REPLACES D2947)
8	26	18	D4061-1	CUSHION (REPLACES D2182B055)
	8	8	AN4-12A	BOLT
20			AN4-15A	BOLT
	52	52	AN4-20A	BOLT
20	52	32	NAS1149D0463J	WASHERS (OR AN960JD416)
	8	8	AN970-4	WASHER
20	60	40	MS21042L4	NUT (OR MS21042-4)

5.2 Parts List Bearpaw Installation

(For Skidtubes equipped with Standard and Training Wearplates)

Qty -111	Part Number	Description
X	D205-564-111	BEARPAW INSTALLATION
20	D2274	RADIUS BLOCK
20	D2529	WASHER
4	D3544-041	CLAMP
6	D4060-7	CLAMP
2	D4060-9	AFT BEARPAW CLAMP
8	D4061-1	CUSHION
2	D5423-1	BEARPAW
16	AN4-20A	BOLT
20	AN4-22A	BOLT
20	NAS1149D0463J	WASHERS (OR AN960JD416)
20	MS21042L4	NUT (OR MS21042-4)

Change Record

PAGE 1 OF 1

Part Number: D205-564-011

Description: BEARPAW INSTALLATION

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
002	98.08.06	KE	D205-564 REV C, DSI 9108 REV A, D2771 REV A	
			D2182B060, D2274, D2521, D2522, D2529 (SS BOLT DESIGN)	
003	99.03.03	KE	D205-564 REV B	
			D2182B060 REV C, D2274, D2521, D2522, D2529 (BACK TO AN4 BOLTS	
			BUT w/ C'BORE ON TOP AND BOTTOM OF BEARPAW	
004	99.03.03	KE	SAME AS CHG 003 BUT w/ DEO 9143 REV A (NO TOP C'BORE	
			ON BEARPAW)	
005	99.11.01	KE	DR-D205-564 REV E, D205-564 REV B, DSI 9050 REV A, DSI 9058 REV D	
			DSI 9171 REV A, DEO 9143 REV A, D2182B060, D2521, D2529,	
			D2522-074 REV E, AN4-17A, AN960JD416, MS21042L4 (SAME AS CHG004	
			BUT w/ SHORTER CLAMP AND LONGER BOLTS PER DSI 9171)	
006	00.01.06	DS	D205-564 REV C (CHANGE TO D2946 CLAMPS & AN4-15A BOLTS)	
007	06.08.28	KJ	D205-564 REV E	
008	06.12.22	KJ	WAS K10015 CHG 002	
009	15.06.04	KJ	ICA-D205-564 REV 3, D4060 REV B, D4061 REV C	15-574